

in the cross-slide carriage. The leaf is therefore made loose, which is an objectionable feature, but lugs have been carried up on the casting on both sides of the leaf as shown, to give good support; these lugs are carefully finished to fit the leaf, and the latter is located and held in place by ground plugs.

In Fig. 9 is shown a boring jig which receives the work *A* between two uprights. The work in this case is the tailstock of a lathe where two holes *B* and *C* are to be bored out. The bottom surface of the tailstock is finished before boring, and is located on the finished bottom of the jig by means of a key

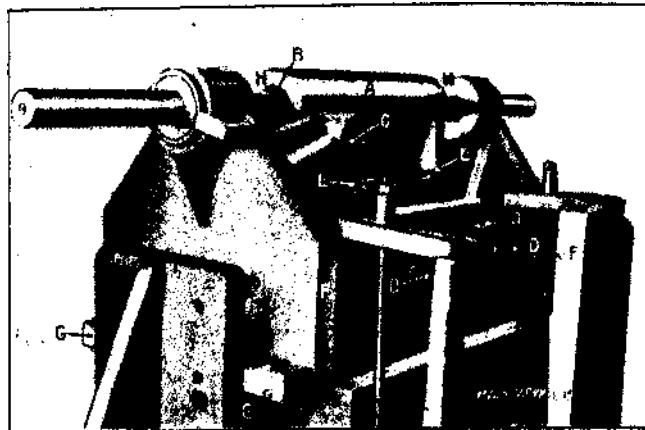


Fig. 9. Common Type
of Medium-size Boring
Jig

and keyway. The keyway is cut in the jig and is a little wider than the key in the work, and the act-screws *I* bring the key against one side of the keyway, that side being in accurate relation to the hole *B* to be bored in the tailstock.

Longitudinally the work is located by a stop-pin, against which it is brought up by a set-screw from the opposite side. The tail-stock is held to the jig by bolts *E* exactly as it is held on the lathe bed.

The placing of the set-screws *I*) at different heights is one of the features of the jig; this makes it possible for the jig to take tailstocks of various heights for different sizes of lathes, raising blocks being used for the smaller sizes. The raising